J. P. Sauer & Sohn gegründet 1751

SAUER 202

Handling and Safety Instructions

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1 General instructions

Be sure to read through these instructions carefully before any manipulation on this SAUER gun.

Understanding these instructions and the technically correct implementation of the information contained therein are **imperative** for the correct preparation and safety during handling, maintenance and care of this SAUER gun. Do not use the gun until you have fully understood all safety instructions and handling procedures. Should you require further information, do not hesitate to contact your dealer, importer or the manufacturer.

Please observe the local and national legislation governing the ownership, carrying and use of firearms.

Be aware that this gun, like all firearms, is dangerous. The gun accompanying these Handling and Safety Instructions has been sold under the express understanding that the manufacturer and the importer of the gun decline any responsibility for consequences of manipulations on the gun or use of the gun. This applies in particular to liability for bodily harm or damage to property resulting in part or in whole to:

– use with criminal intent or negligent use,
– improper or careless handling,
– defective, incorrect, hand-charged or recharged ammunition,
– inadequate care of the gun (e.g. corrosion, damage),
– disregard of malfunctions,
– resale in contradiction of regional legislation and regulations,other circumstances beyond our direct and immediate control
– other circumstances beyond our direct and immediate control.

These limitations apply regardless of whether liability is asserted on the basis of contract, negligence or strict liability (including any failure to warn).

The manufacturer and the importer are not liable for incidental or consequential damages such as loss of use of property, commercial loss or loss of earnings and profits.

2 Safety regulations

- Never use the gun under the influence of alcohol or drugs, during illness or other complaints; they may influence your judgement and reflexes.
- Always treat the gun as loaded and unlocked until you have made sure to the contrary by unloading it.
- During all manipulations, keep the muzzle of the gun pointed in a safe direction. Safe directions are defined as areas where there are no people, other living creatures or other people's property.
- Never point the gun at doors, window panes, walls, concrete, stones or other flat surfaces (including water). Shots can penetrate such surfaces or be deflected into unsafe directions by them.
- Never aim at yourself or other people.
- Never rely on safety mechanisms. They are never a substitute for careful and correct handling of the gun.
- Always handle your gun as if the safety mechanisms were not functional. The best safety device is the correct, well-exercised and secure handling of the gun.

- Never shoot a gun into which there has been ingress of water, sand, dirt or other foreign bodies.
- Never release the tension on the firing pin 106 merely by pulling the trigger.
- Never let a loaded gun out of your hands.
- Always unload the gun immediately after shooting, before putting it down, putting it in its case or handing it to another authorised person.
- Never hand the gun to any person who has not thoroughly familiarised himself or herself with the safety regulations and handling of the gun by reading the accompanying instructions.
- Never leave the gun lying around unattended. Unauthorised persons can cause damage or threaten or kill people with it, for which you might be liable.
- Never store the gun loaded, but remove the magazine and verify through unloading there is no round in the barrel chamber.

2.1 Safety instructions

In the individual sections of these instructions, the following safety indications alert you to various risks:

	WARNING!
Information on risks which, if not scrupulously observed, can lead to severe bodily harm or death.	

	CAUTION!
Information on risks which, if not scrupulously observed, can lead to bodily harm or damage to the gun.	

	CAUTION!
Information on technical requirements which, if not scrupulously observed, can lead to damage to the gun.	

- Each safety indication consists of:
  - a header with a signal word, icon and a corresponding colour shading
  - a specification of the type and source of the risk
  - a specification of potential consequences if the safety indications are not observed
  - specifications of measures and prohibitions designed to avoid risks

3 Product description

3.1 Main parts

Fig. 1

Item	Description
100	Bolt
200	Magazine tube
300	Barrel
400	Main stock
500	Front stock
600	Magazine
700	Trigger

3.2 Main features

The SAUER 202 is a high precision hunting gun built to the latest technology. It is an easy to handle repeater with rifle trigger which can be fitted with a rear set trigger.

The modular construction makes it easy to change individual components including the caliber.

Both mechanical and optical aims can be fitted.

There is a wide range of accessories available. The SAUER 202 is also available as a left-handed version.

3.3 Scope of delivery

The standard scope of delivery includes:

– 1 x gun
– 1 x magazine
– 1 x special socket spanner (2 parts)
– 1 x Allen key for dismantling the barrel
– 1 x Handling and Safety Instructions manual
– 1 x 10 g SAUER Premium gun grease
– 1 x SAUER plastic case
– 1 x Warranty card

Fig. 2, Standard scope of delivery in plastic case

4 Transporting the gun

4.1 Transport in assembled state

Procedure:

1. Remove the magazine (see section 5.8.1).
2. Unload and lock the gun (see section 5.6, 6.2).
3. Remove the bolt (see section 5.7.2).
4. If necessary remove the sling attachment (see section 7.1) to prevent scratching the stock components.
5. Clean the gun (see section 11).

WARNING!

Uncontrolled discharge of shot
May lead to death or severe injuries

- For your own safety and for the safety of others, always transport the gun in the unloaded condition (see section 5.6) and decocked.
- Never carry a cocked gun containing a round in the barrel chamber.
- Always carry the gun in such a manner that, should you fall or otherwise slip, you are able to control the direction of the muzzle.
- Transport the gun separate from the ammunition in a locked carrying case.
- The gun and ammunition must not be accessible to children and other inexperienced or unauthorised persons.
- Ensure that you comply with all regional and national laws relating to the transport of firearms.

4.2 Transport in the compact case

Procedure:

1. Remove the magazine (see section 5.8.1).
2. Unload the gun (see section 5.6).
3. Remove the bolt (see section 5.7.2).
4. Remove the sights/accessories (see section 13).
5. Remove the sling attachment (see section 7.1).
6. Clean the gun (see section 11).
7. Remove the main stock (see section 7.2).

5 Handling the gun

5.1 Preparing the gun

Note:
The gun is supplied with a protective and preserving oil and grease coating, and excessive protective oil and grease must be removed prior to first commissioning.

The SAUER 202 is supplied in a shock-proof durable plastic case.

For safety reasons the bolt and the magazine must not be inserted during:

– first commissioning and

– taking possession of the gun.

WARNING!

Undefined condition of the gun
May lead to death or severe injuries

- If the shooter takes possesion of the gun in any other condition it must be treated as loaded and unlocked.

Procedure:

1. Unload the gun (see section 5.6).
2. Remove the bolt (see section 5.7.2).
3. Check whether ammunition is still in the barrel chamber or in the magazine.
4. Clean the barrel (see section 11.2).
5. In addition during first commissioning:
   – Clean external metal surfaces (see section 11).
6. If supplied in compact case:
   – Fit the main stock (see section 8.2).

5.2 Ammunition

WARNING!

Incorrect ammunition
May lead to death or severe injuries and damage to the gun

- For your gun, use only commercial grade ammunition in the original packaging, which corresponds to the calibre of the gun.
- Never use recharged, "reconditioned", hand-charged or non-standard ammunition in your gun.
- Never use dirty, wet, corroded, bent, damaged or oiled ammunition.
- Never spray lubricants, preservatives or cleaning agents directly onto the rounds.
- Never leave the ammunition lying around unattended.

5.3 Loading the gun (ready to fire)

WARNING!

Insufficient awareness of the dangers
May lead to death or severe injuries

- Never load or unload the gun inside a vehicle, inside a building or any other confined space (except in a designated firing range).
- Before loading, always wipe off any excess grease and oil and check that there is no obstruction in the bore of the barrel.
- Always keep the muzzle of the gun pointed in a safe direction.
- Do not place the finger onto the trigger tongue, but outside the trigger guard.
- Do not load the gun by inserting the magazine until immediately before shooting.
- Never rely on safety mechanisms. They are never a substitute for careful and correct handling of the gun.
- Never let a loaded gun out of your hands.

Procedure:

1. Unlock the gun (see section 6.1).
2. Insert the bolt (see section 5.7.3).
3. Open the bolt and pull it back to the stop.
4. Fill the magazine (see section 5.8.3).
5. Insert the magazine (see section 5.8.2).
6. Push the bolt forward and lock.
7. Lock the gun (see section 6.2).

The gun is loaded and ready to fire.

5.4 Discharging a shot

WARNING!

Insufficient awareness of the dangers
May lead to death or severe injuries

- Ensure that the target and the environment allow shots to be fired without danger.
- When discharging shots, ensure that your hands or any other parts of the body are located in front of, over or adjacent to the barrel muzzle or the ejection port.
- Never allow other persons to stand beside you where they might be struck by ejected cartridge cases.
- Always wear ear protection and safety glasses when shooting. Alert bystanders to the importance of wearing ear protection.
- Immediately stop shooting and unload the gun if you suspect that a round has not been chambered properly, a case is jammed, a bullet is lodged in the bore or a discharge sounded or felt weak or abnormal.
- Never attempt to dislodge a blockage in the barrel by firing another round.

Procedure:

1. Aim the gun at a safe target.
2. Unlock the gun (see section 6.1).
3. If necessary, set the trigger (see section 5.9.2).
4. Place finger on trigger tongue and pull back the trigger tongue to discharge the shot. The trigger behaviour depends on the trigger fitted (see section 5.9).
5. Keep the gun aimed at the target and repeat and fire further shots as required.
6. If the magazine is empty, reload the gun (see section 5.5).
7. Lock and unload (see section 5.6).

WARNING!

Gun is ready to fire
May lead to death or severe injuries

- If you decide to end the shooting session, immediately unload the gun.

5.5 Reloading during shooting

WARNING!

Insufficient awareness of the dangers
May lead to death or severe injuries

- Never let the gun out of your hands.
- Keep the gun pointed at the safe target.

Procedure:

1. Lock the gun (see section 6.2).
2. Remove the empty magazine (see section 5.8.1).
3. Unlock the gun (see section 6.1).
4. Open the bolt and pull it back to the stop.
5. Fill the magazine (see section 5.8.3).
6. Insert full magazine and check engagement (see section 5.8.2).
7. Push the bolt forward and lock.
8. Lock the gun (see section 6.2).

The gun is loaded and ready to fire.

5.6 Unloading the gun

WARNING!

Gun is ready to fire
May lead to death or severe injuries

- Never let the gun out of your hands before it is unloaded.
- The gun is loaded, a round is located in the chamber of the barrel.
- Never place your hand over the ejection port of the bolt.

Procedure:

1. Lock the gun (see section 6.2).
2. Aim the gun at a stop-butt.
3. Remove the magazine (see section 5.8.1).
4. Unlock the gun (see section 6.1).
5. Open the bolt.
   – The cartridge or cartridge case is pulled out of the barrel chamber and ejected.
6. Check that the cartridge has been ejected and there is no more cartridge in the barrel chamber.
7. Empty magazine.
8. Pick up ejected round and clean the gun.

WARNING!

Gun has not been cleaned sufficiently
May lead to death or severe injuries and damage to the gun

- The gun must be cleaned after every shooting session (see section 11).

The gun is unloaded.

5.7 Bolt

5.7.1 Cocking the bolt

In order to insert the bolt **100** into the gun, the firing pin must be cocked.

A cocking indication provides information about the cocking state of the bolt.

Procedure:

1. Insert the tapered end of the supplied key into the side opening of the lock **113**.
2. Turn the lock towards the cocking wheel until it engages.

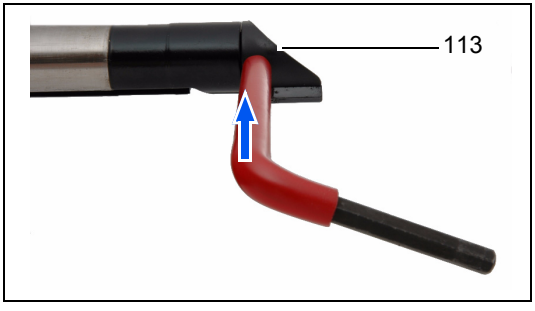

Fig. 3, Cocking the bolt

Fig. 4, Tension indication 103 of the bolt (left: cocked, right decocked)

5.7.2 Removing the bolt

Procedure:

1. Unlock the gun (see section 6.1).
2. Open the bolt and pull approximately half way back.
3. Fully push in the bolt lock bolt slide **711** and pull out the bolt.

Fig. 5

5.7.3 Inserting the bolt

WARNING!

Uncontrolled discharge of shot
May lead to death or severe injuries

- The gun must be unloaded.

1. Unlock the gun (see section 6.1).
2. Cock the bolt (see section 5.7.1).
3. Press the bolt lock bolt slide and insert the cocked bolt into the magazine tube, close and lock.

CAUTION!

Gun may be damaged

- Never use force when inserting the bolt.

4. As functional check: carry out a repeater action.
5. Check the safety functions with the gun unloaded:
   - The safety and unlocking bolts must be freely moveable.
   - Firing a shot must not be possible in the locked state.
   - The bolt must not open in the locked state.
   - With the trigger set the gun must automatically unset when the bolt is opened.
6. If problems arise during the functional check or with the safety function, remove the bolt and repeat steps 1 to 5.

5.7.4 Uncock the firing pin

WARNING!

Uncontrolled discharge of shot
May lead to death or severe injuries

- Only uncock the firing pin with the gun unloaded and the barrel chamber empty.

Procedure:

1. Unload the gun and check that there is no round in the barrel chamber (see section 5.6).
2. Pull the trigger tongue and slowly close the bolt with the trigger tongue held pulled.

Note:

- The cocking indication must not be visible (see Fig. 4).

5.8 Magazine

5.8.1 Removing the magazine

Procedure:

1. Hold magazine **600** by hand.
2. If fitted: Push magazine safety towards the magazine (see section 10.2).

CAUTION!

Magazine may fall out
Magazine may be damaged

- When removing the magazine always keep your hand exactly underneath the magazine.

3. Press the stud **207** with the index finger of the same hand.
4. Remove magazine.
5. Empty magazine.

Fig. 6

5.8.2 Inserting the magazine

Procedure:

1. Insert the magazine into the magazine shaft and push upwards until the magazine engages audibly. Do not jam the magazine.
2. If fitted: Push magazine safety towards the barrel (see section 10.2).

5.8.3 Loading the magazine

Procedure:

1. Push the rear feeder down.
2. Push the round from the front under the magazine lip.

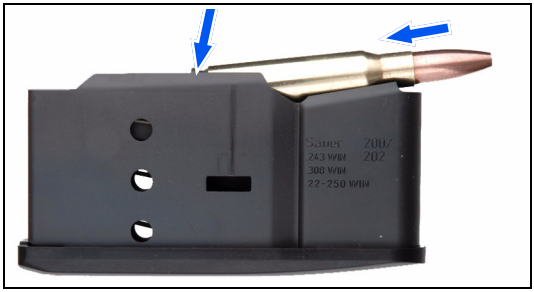

Fig. 7

5.9 Trigger

Three trigger variants are available for the SAUER 202: A rifle trigger, a rifle trigger with rear set trigger, and a pressure point match trigger.

CAUTION!

Gun may be damaged

- The trigger can be changed, but this must only be carried out by a gunsmith.

5.9.1 Rifle trigger

Note:

- The trigger weight has been set to approx. 15 N (1,500 g) at factory.

The rifle trigger is a direct trigger without creep.

– The shot is fired after the resistance has been overcome.

WARNING!

Uncontrolled discharge of shot
May lead to death or severe injuries

- For safety reasons the rifle trigger weight must only be modified by a qualified gunsmith.
- The minimum setting for the trigger weight is 10 N (1,000 g).

5.9.2 Rifle trigger with rear set trigger

Note:

- The trigger weight of the rifle trigger has been set to approx. 13 N (1,300 g) at factory.

The rifle trigger with rear set trigger is a direct trigger without creep, which allows for a reduced trigger resistance by way of setting. The trigger resistance of the rear set trigger can be set individually (see page 15).

– The shot is fired after the resistance has been overcome.

Priming

WARNING!

Uncontrolled discharge of shot
May lead to death or severe injuries

- For safety reasons the rifle trigger weight must only be modified by a qualified gunsmith.
- The minimum setting for the trigger weight is 10 N (1,000 g).
- The set trigger can be triggered already by the slightest vibration. Therefore the trigger must not be set until immediately before firing the shot. Aim the gun at a stop-butt. If the intended shot cannot be fired, immediately lock and reset the gun.

Procedure:

1. Unlock the gun (see section 6.1).
2. Press the trigger tongue **706** forward with the thumb until it engages.

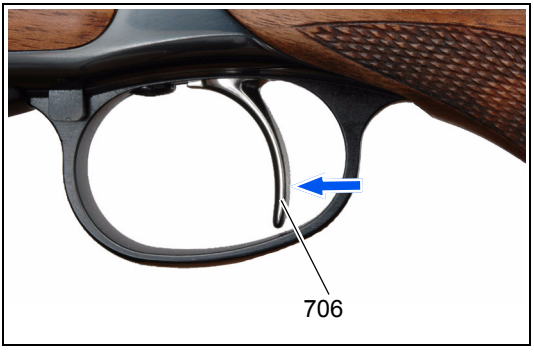

Fig. 8

Resetting

Procedure:

1. Lock the gun (see section 6.2).
2. Aim the gun at a stop-butt.
3. Grip the trigger tongue with the thumb and index finger and pull back slowly.

Note:

- If the bolt is opended, a reset will be carried out automatically.

Modifying the trigger weight

Note:

- The trigger weight of the set trigger has been set to approx. 3 N (300 g) at factory. It can be modified using the adjustment screw **729**.

WARNING!

Uncontrolled discharge of shot
May lead to death or severe injuries

- The trigger weight must not be adjusted to a value below 3 N (300 g).
- Set the set trigger for rough hunting use clearly harder than for use in the shooting range, because the trigger finger often loses feeling during the cold season.
- If the gun unsets automatically when locked, the trigger weight has been set too low. It must immediately be set to a value where the gun does not automatically unset when locked.

Adjusting downwards:

– Turn the adjustment screw **729** clockwise.

Adjusting upwards:

– Turn the adjustment screw **729** anti-clockwise.

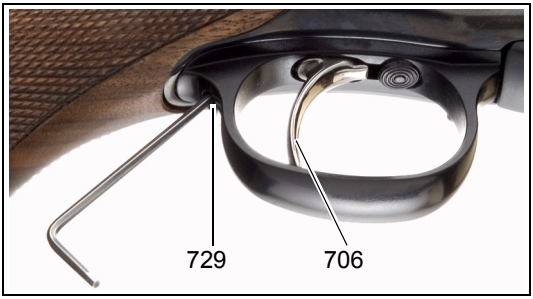

Fig. 9

5.9.3 Match trigger

Note:

- The trigger weight has been set to approx. 7 N (700 g) at factory.

The match trigger is a pressure point trigger with adjustable creep.

– The trigger tongue must be pulled until it reaches a noticeable resistance (pressure point).

– The shot is fired after the resistance has been overcome.

WARNING!

Gun is ready to fire

May lead to death or severe injuries

- For safety reasons the trigger weight must only be modified by a qualified gunsmith. He can adjust the trigger weight between approx. 5 N (500 g) and 10 N (1,000 g).

Creep adjustment (see Fig. 9)**:**

Note:

- The creep travel cannot be adjusted to "zero", there will always be a travel by design.

Short creep:

– Turn the adjustment screw **729** clockwise.

Longer creep:

– Turn the adjustment screw **729** anti-clockwise.

WARNING!

Gun is ready to fire

May lead to death or severe injuries

- Any screws sealed with red varnish must not be interfered with by the user. If these screws are manipulated, the warranty will be void.
- The screw for reducing the creep must only be turned clockwise to a degree that the safety lock will still work properly.
- If the free movement of the safety lock is impeded, the screw **must** be **immediately** turned back **anti-clockwise** until the normal safety lock function is restored.

5.10 Sights

Dependent on the model selected the SAUER 202 is supplied with various sights or without open sights. If a gun is supplied with open sights, those have been - depdendent on the sight type - calibrated to 50 or 100 metres. The sights can be changed at a later date, but this should only be carried out by a gunsmith.

6 Safety lock

The safety lock of the SAUER 202 is an indirect firing pin safety lock.

It locks the trigger tongue, the trigger stop, and the firing pin nut and thus blocks all safety-relevant components.

Its function is based on a principle proven a million times over: A single function – a single button.

– The safety lock bolt is positioned at the top of the handle of the stock.

– The unlock bolt is positioned well protected and easy to grip within the trigger guard in front of the trigger tongue.

6.1 Unlocking

Procedure:

1. Slide the unlock bolt **714** with the trigger finger upwards to the stop.
   – The safety lock bolt **210** is also pushed upwards thereby and releases a red signal ring.

Note:
Gun unlocked:

– Red signal ring visible

– The safety lock bolt can be felt with the thumb

Fig. 10, Gun unlocked

6.2 Locking

	CAUTION!
Gun may be damaged	
• If the gun has its trigger set and is then locked, the gun cannot be unlocked and opened. To unlock and open the gun again, it has to be unset manually (see section 5.9.2).	

Procedure:

1. Press the safety lock bolt **210** down with thumb up to the stop.
   – The unlocking bol **714** is pushed out of the trigger device at the bottom where it can be easily controlled with the trigger finger.

Note:
Gun locked:

– Red signal ring not visible

– The unlocking bolt can be felt with the trigger finger

–

Fig. 11, Gun locked

7 Dismantling

WARNING!

Gun is ready to fire
May lead to death or severe injuries

- There must be no magazine in the gun.
- Before stripping your gun, ensure once again that it is unloaded (see section 5.6).

7.1 Removing the sling attachment

Procedure:

1. Firmly press in the spring bolt.
2. Turn the sling attachment gently and pull out.

Fig. 12, rear sling attachment bushing

Note:

- Clean and oil the sling attachment regularly.

7.2 Removing the main stock

Procedure:

1. Removing the string attachment (see section 7.1).
2. Unscrew the main stock screw in the hole of the main stock **401** anti-clockwise using the long end of the special spanner supplied (approx. 5 turns).
3. Remove the main stock by pulling downwards.

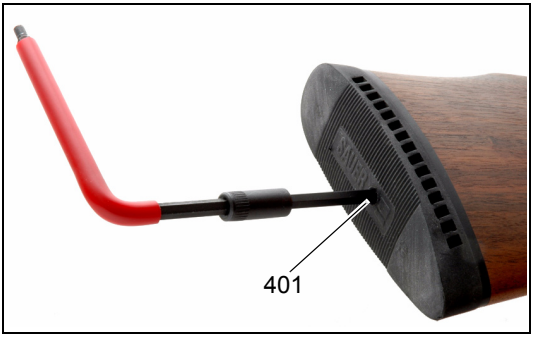

Fig. 13

7.3 Front stock removal

Procedure:

1. Removing the string attachment (see section 7.1).
2. Insert the special spanner with the long end through the sling attachment bushing **503**.
3. Turn the front stock screw with the special spanner clockwise until the resistance at the spanner disappears.
4. Remove the front stock **502** by pulling it to the front.

	CAUTION!

Gun may be damaged

- With a short rifle the front stock must only be removed by a gunsmith.

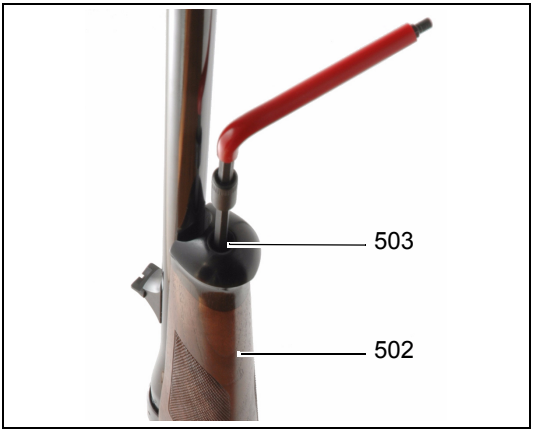

Fig. 14

7.4 Barrel removal

Procedure:

1. Open and remove the bolt (see section 5.7.2).
2. Remove the front stock (see section 7.3).
3. With the spanner supplied undo the clamping screws **203** but do not remove them.
4. Only fully pull out the clamping screw **203A**.
5. Remove the insert **208** by pulling downwards.
6. Pull the barrel **301** off the magazine tube **200**, if necessary, turn to and fro whilst pulling.

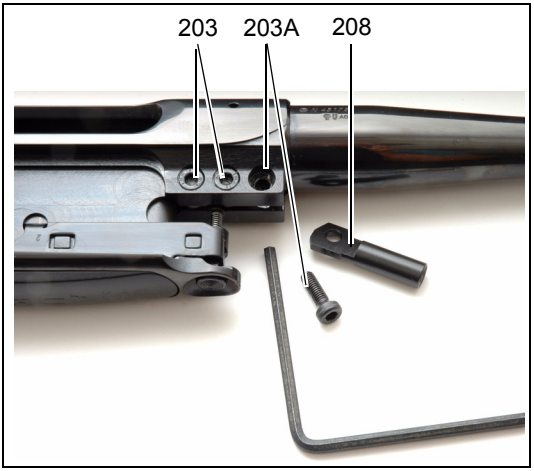

Fig. 15

	CAUTION!

Gun may be damaged

- With a short rifle the barrel must only be removed by a gunsmith.

8 Assembly

CAUTION!

Gun may be damaged

- Only assemble cleaned gun parts.
- Only tighten the screws for the stock attachment by hand (only operate the special spanner with two fingers), (see Fig. 17).

8.1 Fitting the barrel

CAUTION!

Gun may be damaged

- Do not use force when inserting the barrel into the magazine tube.
- Only tighten clamping screws until the hexagonal leg in the screw starts turning with a spring action (noticeable torque limit), (see Fig. 16).
- The spanner must not be extended by attaching a tube.
- When using a torque spanner tighten the screw to 7 Nm.

Procedure:

1. Insert the barrel **301** with the barrel groove facing downwards up to the stop into the magazine tube.
2. Push the insert **208** from below up to the stop into the clamping device. Ensure that the barrel is aligned in such a way that the insert remains easy to move all the time.
3. Turn the barrel until the insert engages in the barrel groove.
4. Insert the clamping screw **203A**.
5. Gently tighten the clamping screws **203**, **203A**.
6. Inserting and locking the bolt (see section 5.7.3).
7. Check the bolt action with the gun unloaded.
8. Alternatively tighten the clamping screws **203** and **203A** a little more until the barrel is held without tension (alternative: tightening with a torque spanner: torque 7 Nm).
9. Fit the front stock (see section 8.3).

Fig. 16

Note:

- A test firing is required each time the barrel is changed.

8.2 Fitting the main stock

Corresponding figure, see Fig. 13.

Procedure:

1. Slide the main stock onto the gun.
2. Hand-tighten the main stock screw clockwise with the long end of the special spanner supplied (approx. 5 turns).
3. Fit the sling attachment (see section 8.4).

8.3 Fitting the front stock

Corresponding figure, see Fig. 17.

Procedure:

1. Slide the front stock **502** onto the gun and press the sides of the front stock into the sides of the magazine tube.
2. Hand-tighten the front stock screw clockwise with the long end of the special spanner supplied.
3. Fit the sling attachment (see section 8.4).

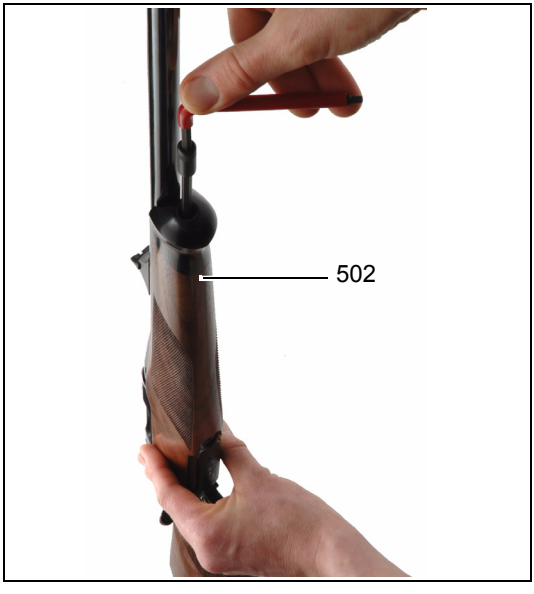

Fig. 17

8.4 Fitting the sling attachment

Corresponding figure, see Fig. 12.

Procedure:

1. Insert the bolt of the rear sling attachment into the sling attachment bushing **407**.
2. Press in the spring bolt.
3. Gently turn the sling attachment until the bolt safety lock engages.
4. Insert the bolt of the front sling attachment into the front sling attachment bushing **503**.

Note:

- The sling attachment must be aligned exactly 90° to the orientation of the barrel.
- The bolts must protrude clearly above the edge of the sling attachment body.

9 Modular principle

Components manufactured to perfect dimensions make it possible to produce a hunting rifle optimally tailored to your needs. It also allows you to modify and specialise your S 202 at a later date.

The complete and current option selection and invidual possibilities can be found in the price list, the SAUER hunting catalogue or most conveniently on the SAUER homepage (www.sigsauer.de).

9.1 Caliber change retrofit table

The S 202 allows you to change between the caliber categories "Mini" and "Medium" and between the categories "Magnum" and "Big Game". Dependent on the caliber combination the bolt and/or magazine might also have to be replaced. Changing a barrel, i.e. a caliber change across the categories "Mini-Medium" and "Magnum-Big Game" is not possible.

All information about the barrel contours available for the respective calibers and the required front stocks can be found in the price lits, the SAUER hunting catalogue or most conveniently on the SAUER homepage (www.sigsauer.de).

9.1.1 Mini and Medium calibers

Barrel with caliber	Magazine	Bolt
.222 Rem.	Mini	Mini
.223 Rem.	Mini	Mini
.22-250 Rem.	Medium Short	Medium Short
.243 Win.	Medium Short	Medium Short
.25-06 Rem.	Medium	Medium
6,5x55	Medium	Medium
6,5x57	Medium	Medium
.270 Win.	Medium	Medium
7x64	Medium	Medium
.308 Win.	Medium Short	Medium
.30-06	Medium	Medium
8x57IS	Medium	Medium
9,3x62	9,3x62	Medium

9.1.2 Magnum and BigGame calibers

Barrel with caliber	Magazine	Bolt
6,5-284 Norma	Magnum	Magnum for Medium
6,5x68	Magnum	Magnum
.270 Wby. Mag.	Magnum	Magnum
7 mm Rem. Mag.	Magnum	Magnum
.300 Win. Mag.	Magnum	Magnum
.300 Wby. Mag.	Magnum	Magnum
8x68S	Magnum	Magnum
.375 H&H	.375 H&H	Magnum
.416 Rem. Mag.	.416 Rem. Mag.	Magnum
.458 Lott	.458 Lott	Magnum

10 Extras

10.1 Muzzle brakes

If your SAUER 202 is equipped with a muzzle brake (MagNaPort, Pendelton or SAUER muzzle brake) the sound pressure during firing increases by approx. 30 percent. This can result in severe damage to the hearing including deafness. For this reason a suitable ear protection must be worn whenever the gun is used.

	WARNING!
Increased sound pressure **Potential severe hearing damage** • When firing the gun with a muzzle brake always wear a suitable ear protection.	

10.1.1 SAUER muzzle brake

The SAUER muzzle brake is screwed onto the barrel if required. For this the gun must be prepared at factory with a corresponding thread and a rear offset sight. If the brake is not in use the barrel thread is protected by a metal screw cap included in the scope of delivery.

The gun is supplied ex factory with the protective cap attached and has been calibrated in this configuration. To remove the protective cap unscrew it anti-clockwise from the barrel.
To attach the muzzle brake, place the supplied brake onto the barrel thread and hand-tighten clockwise.

Fig. 18

Note:

- With every change from protective cap to muzzle brake or vice versa the gun must be recalibrated, because the the aiming point position will change considerably dependent on the chosen thread attachment!

10.2 Magazine lock MagLock

The special magainze lock MagLock is a 100% effective safety lock against unintentional unlocking of the magazine. Nonetheless, the shooter can rapidly change the magazine when required.

To lock (a) the magazine unlock button slide the caop on the button forward. To unlock (b) slide the cap back.

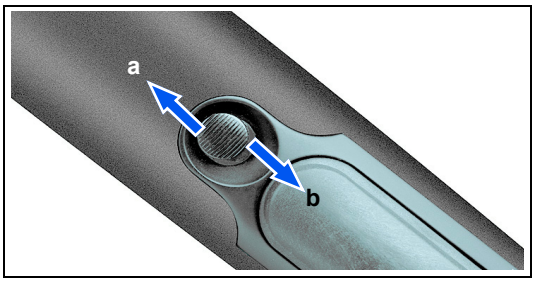

Fig. 19, a) locking, b) unlocking

10.3 Express sights

The SAUER Express sights are the perfect aiming device for hunting moving game or for all those who frequently hunt without telescopic sights. The sights consist of an Express sight with a mechanical sight and a flap. The Holland & Holland front sight consists of a large white bead sight and a small brass bead sight which is visible whent he large front sights are folded.

Guns with these sights are always calibrated as follows:

– Fixed sight with large white bead sight to 50 metres (letting the aim rest),

– Folding sight with small brass bead bead sight to 100 metres (letting the aim rest).

Fig. 20

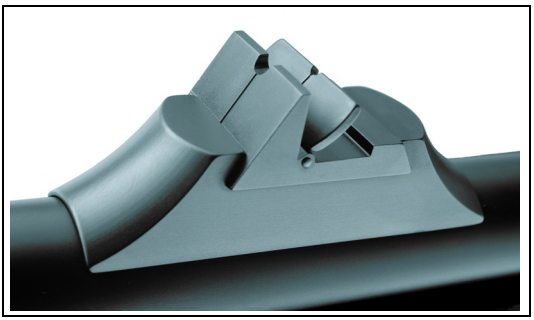

Fig. 21

11 Care

11.1 General

The proper functioning and precision of the gun can only be maintained through regular and expert care. The gun must be cleaned and protected against corrosion after each use. The bore must be cleaned and protected against corrosion after each firing. Wooden stocks must be treated with a suitable agent in accordance the corresponding instructions and must be protected against the weather.

For the optimum care for your SAUER 202 we recommend SAUER care products, e.g. the SAUER Premium gun grease.

For a normal cleaning it is sufficient to remove or dismantle the following gun parts:

- Magazine
- Bolt
- Rifle sling

If the gun has been exposed to extreme moisture or is heavily soiled, it is recommended to remove or dimantle the following gun components:

- Bolt
- Magazine
- Telescopic sights
- Rifle sling
- Main stock
- Front stock

WARNING!

Gun is ready to fire
May lead to death or severe injuries

- There must be no magazine in the gun.
- Before stripping your gun for cleaning, ensure once again that it is unloaded (see section 5.6).

11.2 Cleaning the barrel

CAUTION!

Gun may be damaged

- Never clean barrel from the front end and do not use a steel or brass wire brush as it can destroy the smooth surface of the barrel. Use a suitable cleaning rod and a brush of matching caliber.
- Detergents can damage the surface of the gun. Read the manufacturer's indications and warnings before using solvents or cleansers.

Procedure:

1. Unload the gun (see section 5.6).
2. Remove the bolt (see section 5.7.2).
3. Instead of the bolt insert a cleaning aid ("False lock“) for the exact centred guidance of the cleaning rod.
4. Clean the bore and barrel chamber from the back using suitable fluids or grease (observe the respective instructions for use) and a suitable, caliber matched, bronze or plastic cleaning brush.

5. Check whether deposits of the rounds have collected in the sections. If necessary, clean the barrel with a commercial grade barrel cleaning agent (observe the respective instructions for use) designed for firing residue.
6. Coat the barrel bore and the barrel chamber with a little gun oil or gun grease.
7. Dry the barrel bore and the barrel chamber from the back usng a plastic coated cleaning rod of the correct caliber

11.3 External metal and wood surfaces

For the care and preseveration of the external metal and wood surfaces we recommend SAUER Premium gun grease. Minute spherical Teflon® particles seal the pores of all wood and metal surfaces and provide perfect protection and optimal sliding characteristics.

Benefits:

- dry surfaces - dust etc. does not adhere;
- water and salt water proof;
- absolute corrosion protection;
- perfect slliding characteristics, reduced wear;
- resistant to sweaty palms;
- pressure resistant up to 57,000 kg/cm^2;
- temperature resistant from -50 to +230 °C;
- perfect protection and care for steel **and** wood;
- neutral smell;

	CAUTION!
Gun may be damaged	
• Caring for the external metal surfaces is particularly important in wet weather or if the metal surfaces have come into contact with sweaty body parts.	
• Always wipe dry the gun prior to preservation.	

Procedure:

1. Thoroughly clean the gun using suitable cloths and cleaning agents.
2. Thinly apply the grease with a cloth or sponge over the whole gun (including the stock) including all mechanical and moveable parts.

3. After a reaction time of at least 60 minutes wipe dry and polish the gun with a clean cloth.
4. Dependent on the weather and frequency of use the protective effect will last between two to six months.

Note:

- The sling attachments must also be cleaned regularly and their locking mechanism oiled.
- So-called "water stains" on the stock after rain cannot be avoided. Dependent on the limestone, dust and dirt particle content of the rain this phenomenon is stronger or weaker. It is not a defect in the stock finish.

12 Trouble-shooting

12.1 Cause and correction of malfunctions

Gun maintenance (cleaning and inspection) according to the instructions can prevent malfunctions.

Should, nevertheless, a malfunction occur during shooting, proceed as follows:

WARNING!

Uncontrolled discharge of shot
May lead to death or severe injuries

- Hold the gun pointed in the firing direction (safe direction) and keep your finger off trigger tongue while you carry out the steps described below.

1. Remove magazine and unload the gun (see section 5.8.1).
2. Open the bolt.
   – The cartridge or cartridge case is pulled out of the barrel chamber and ejected.
3. Check that no bullet, round, cartridge case or foreign matter is in the barrel chamber or barrel. If a projectile is lodged in the bore, strip the gun (see section 7) and have the blockage removed with a suitable tool by a qualified gunsmith.
4. Remove all rounds, cases or foreign bodies. Clean, lubricate and assemble the gun (see section 11 and 8).
5. Have the gun inspected by an armourer or gunsmith.

Fault	Potential cause	Remedy
No round chambered.	Magazine not properly inserted, deformed or dirty.	Insert magazine all the way until it engages (see section 5.8.2).
	Gun faulty.	Repair by manufacturer.
Bolt cannot be inserted into the magazine tube.	Bolt lock bolt slide not pressed.	Press bolt lock bolt slide (see section 5.7.3).
	Mainspring is uncocked.	Cock the bolt (see section 5.7.1).
	Gun faulty.	Repair by manufacturer.
Gun trigger cannot be set.	Gun is uncocked.	Cock the gun (see section 5.7.1).
	Gun faulty.	Repair by manufacturer.
Gun cannot be locked.	Gun is uncocked.	Cock the gun (see section 5.7.1).
	Gun faulty.	Repair by manufacturer.
Gun can be neither unlocked nor opened.	Gun has trigger set and is locked.	Unset the gun trigger (see section 5.9.2).
	Gun faulty.	Repair by manufacturer.
Gun trigger is set. When pulling the trigger tongue no shot fires, instead the trigger tongue returns to the start position.	Trigger tongue was pulled to the side.	Reset, pull trigger tongue back straight/linear.
Gun disengages automatically when locking.	Set trigger is set too soft.	Immediately adjust the set trigger harder (see section 5.9.1).

12.2 Shipping the gun

Note:

- Familiarise yourself fully with regional legislation governing the shipping and transportation of firearms.

Procedure:

1. Check the gun to ensure that it is unloaded and decocked.
2. Pack the gun well (if possible in its original packaging) to prevent damage in transit. To prevent the gun being recognised as such during shipping, wrap the original packaging in a second outer layer. Do not include any accessories in the shipment.
3. Enclose a letter stating the following:
   - your full name
   - your full address (state street, not P.O. Box)
   - your daytime telephone number
   - model and serial numbers of the gun
   - detailed description of the problem encountered or the service work to be performed.
4. Send the gun properly insured and carriage-paid (packages without correct postage will not be accepted) to:
   - the sales outlet from which you purchased the gun
   - the local Sauer & Sohn dealer,
   - the Sauer & Sohn agent (importer) for your country
   - if there is no local appointed Sauer & Sohn dealer or Sauer & Sohn agent in your country, to J.P. Sauer & Sohn GmbH.

13 Installation of optics and accessories

Note:

- When fitting the telescopic sights please ensure an exact fit betweent the mounting base and the system housing. If a maladjustment is compensated for by firmly tightening the assembly screws there is a risk that the system sleeve will be damaged or the installation comes loose when a load is applied.

	CAUTION!
Improper installation of telescopic sights Gun may be damaged	
• A damage of the magazine tube results in a change of the barrel attachment which can make changing the barrel difficult or impossible on the one hand, and can have a negative impact on the firing precision on the other. The threads for the assembly screw could also be damaged or destroyed.	
• For differently assembled rifles J. P. & Sohn GmbH will not accept any warranty of the functionality and accurate firing.	

- Please only install mounting bases onto the magazine tube whose radii match those of the sleeve exactly.
- It should also be ensured that the mounting base is not only screwed on but also glued widely and evenly using a **dual component adhesive**.

J. P. & Sohn GmbH recommends the original SAUER swivel mounting

14 Technical Specifications

Functional principle	Repeater rifle
Action type	Direct lug locking in the barrel
Caliber	**Mini:** .222 Rem., .223 Rem. **Medium:** .22-250 Rem.; .243 Win.; .25-06 Rem.; 6,5x55; 6.5x57; .270 Win.; 7x64; .308 Win.; .30-06; 8x57 IS; 9.3x62 **Magnum:** 6.5-284 Norma; 6.5x68; .270 Wby. Mag.; 8x68 S; 7 mm Rem. Mag.; .300 Win. Mag.; .300 Wby. Mag. **BigGame:** .375 H&H Mag.; .416 Rem. Mag.; .458 Lott
Length, overall	**Mini:** approx. 1,115 mm (with barrel length 600 mm) **Medium:** approx. 1,115 mm (with barrel length 600 mm) **Magnum:** approx. 1,170 mm (with barrel length 650 mm) **BigGame:** approx. 1,120 mm (with barrel length 600 mm)
Barrel length	**Mini:** 510, 560, 600 mm **Medium:** 510, 560, 600 mm **Magnum:** 600, 650 mm **BigGame:** 600 mm
Stock length (Monte Carlo stock)	approx. 355 mm
Stock indentation (Monte Carlo stock); from top edge of magazine tube	**front:** 32 mm **centre:** 25 mm **back:** 50 mm
Stock offset	5 mm
Trigger weights	**Pure rifle trigger:** approx. 15 N **Rifle trigger (with set trigger):** approx. 13 N **Set trigger:** approx. 3 N **Match trigger:** approx. 7 N
Magazine content	**Mini:** 3 rounds **Medium:** 3 rounds **Magnum:** 2 rounds **BigGame:** 2 rounds
Replacement magazine	**Medium:** 5 rounds **Magnum:** 4 rounds **BigGame:** 4 rounds
Weight without telescopic sights with steel magazine tube, 600 mm barrel length and Monte Carlo stock.	**Mini:** 3.5 kg **Medium:** 3.5 kg **Magnum:** 3.7 kg **BigGame:** 3.8 kg

Subject to change without notice

15 Accessories

Your SAUER 202 is a modular hunting gun which can be easily adapted to new uses at a later date. The complete and current option selection and invidual possibilities can be found in the price list, the SAUER hunting catalogue or most conveniently on the SAUER homepage (www.sigsauer.de). There you will also find all telescopic sight assemblies, replacement barrels, replacement magazines, sights and any other gun accessories.

In addition Sauer & Sohn offers the following accessories for the perfect transport and stylish presentation of your gun and for successful hunting: More precise information can be found in the catalogue or on the internet at (www.sigsauer.de).

16 Spare parts

J. P. Sauer & Sohn GmbH only supplies to authorised dealers in Germany or to the respective SAUER importer abroad. For ordering spare parts please always contact your dealer who will then forward your order accordingly to the importer (abroad) or Sauer & Sohn (Germany). To enable the speedy and focused processing of your order please always provide the following information when ordering spare parts:

– Model, caliber, barrel length, extras
– Gun number
– Item number from the spare parts list

Designation of the desired spare part

Item designation

100 Bolt assembly
102 Straight pin
103 Striking pin nut
104 Brazed nipple
105 Firing pin spring
106 Firing pin
107 Ejector pin
108 Ejector pressure spring
109 Clamping sleeve
110 Extractor
111 Pin for extractor spring
112 Bolt
113 Lock

200 Magazine tube assembly
201 Magazine ejector spring
202 Magazine case, light alloy or steel
203 3 clamping screws
204 Magazine catch
205 Guide pin
206 Pressure spring for magazine catch
207 Pressure bolt
208 Insert
209 2 Spring pins
210 Safety bolt
211 Threaded bolt
212 Set screw

300 Barrel assembly
301 Barrel
302 Spring collet
303 Pan head screw
304 Pan head screw
305 Fixed sight
306 Sight base
307 Pan head screw
308 Front sight base

Item designation

400 Main stock assembly
401 Main stock
402 Retention sleeve
403 Main stock screw
404 Crown gear
405 Washer
406 Flat head wood screw
407 Sling attachment bushing
408 Butt
409 2 screws for butt

500 Front stock assembly
501 Front stock screw
502 Front stock
503 Sling attachment bushing for front stock
510 "Stutzen" cover

600 Magazine assembly
601 Magazine floor plate
602 Magazine spring
603 Feeder
604 Magazine case

700 Set trigger device
701 Set trigger hammer
702 Straight pin
703 Pressure spring
704 Trigger stop
705 Straight pin
706 Trigger tongue
707 Straight pin
708 Pressure spring
709 2 spacers
710 Rocker lever
711 Bolt handle catch
712 Bolt catch

Item designation

713 Spring for bolt catch
714 Unlock slide
715 2 straight pins
716 Pressure spring
717 Spring bolt
718 Trigger lever
719 Safety lock
720 Spring bolt
721 Pressure spring
722 Adjustment screw
723 Rocker lever
724 Spring bolt
725 Spring
726 Safety lever
727 Spring counter bearing
728 Trigger housing
729 Adjustment screw
730 Roll

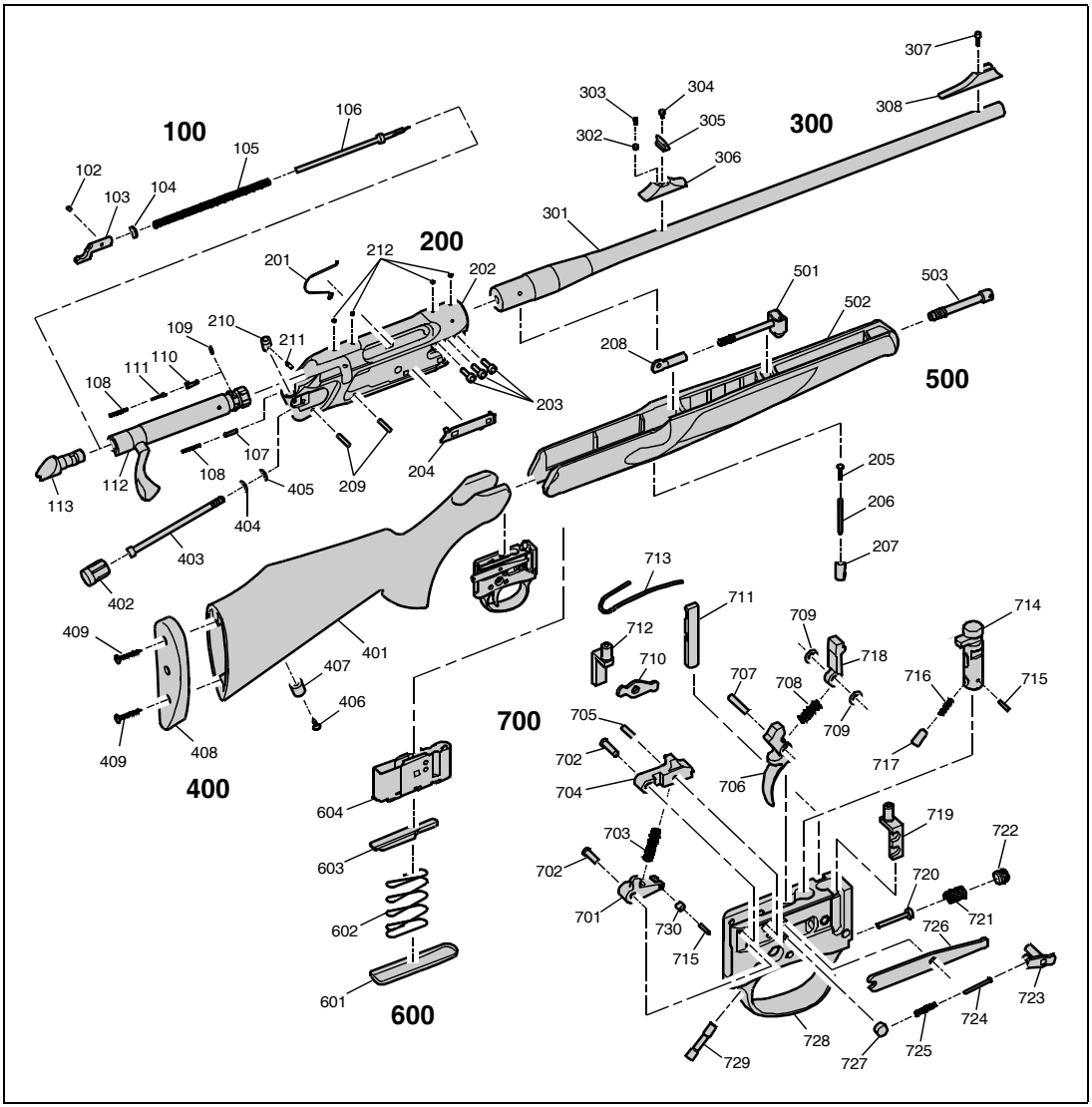

Fig. 22, Spare parts for S 202

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